

Work Order ID 51385

August 20, 2009 3:20:34 PM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID: C

Stop



Item Name: Skidtube Installation

Start Date: 08/24/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *MF*

Date: *09-08-20* Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3507	Rev C

100	0.00
-----	------



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

8/21/09/24

110	0.00
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Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

D

149/8/26

51385

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  CNC Bend I	BENDING MACHINE - SKIDTUBES	0.00							
CNC Delta 100 Bender	Memo Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".	0.00				①		4918126	

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Fwd end of the tube using DT8185								
	2-Cut Aft end at VC using DT8185								
	3-Deburr ends								
	4-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	5-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with 3/16cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using 3/16" drill.****DO NOT OPEN AFT CAP HOLES****								
	7-Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892.								
	9-Open holes section C-C to .375" and locate DT9431 using "T" pin & cleco.								
	10- Drill holes section G-G (DT9431)								
	11-Open Aft & Fwd Cap holes using .208" drill.								
	12-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	13-Open ground wire hole .297" section E-E								

9-8-27

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

14-Deburr holes.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> 8/27/09

Memo

0.00



150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00



9-8-27

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Am 09 - 08 - 27 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M 112391
Exp Date: 3/10/02

Handwritten signature and date 9-8-28

Handwritten initials MB and date 09-08-31

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: M 111682

Handwritten date BE 09/09/02

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871 A&B

Handwritten date BE 09/09/02

8-Deburr Rivet holes.

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

0.00

=> S 08/07/02

Memo



190



Skidtubes

Skidtubes

Skidtubes

Memo

1-Rivet D3506-1/-3 as per Dwg D3507.

0.00

0.00



BE 09/09/02

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

=> S 09/09/02



W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 12:30pm								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 1:00pm								
230	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								

BR 09-09-8

Ø

09/09/08

X1-2

BR 09-09-15

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install Wearplate & Ground Wire inserts as per Dwg D3507.

PR 09-09-15

250

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Inserts

2) 8 09/09/05

(71)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260

0.00



HandFinish
Hand Finishing

HandFinishing

Memo

0.00

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: m112391
Exp Date: 10/20

3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Scews where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: m112391
Exp Date: 10/20

4-Install Plug assemblies as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

XL

BR/ mo 09/09/21

mo 09/09/22

2) S 09/09/23

2) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/9/25 9/10/25

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

27 9/10/25

9/10/25

300

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011

Location: 82

PPP Rev: 13

9/9/25 9/10/25

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/28

RP 09-9-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2962-150RevA

Manufactured

No

110

Each

43.0000

1.0000



3.540 Outer Tube, Extrud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

28672

43

D3504-1RevC

Manufactured

No

170

Each

19.0000

2.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

31234

19

D3504-3RevC

Manufactured

No

170

Each

18.0000

1.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

31232

18

1 M 9/8/26

2 BE 09/09/02

1 BE 09/09/02

W/O:		WORK ORDER CHANGES					
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 525

Start Date: 08/24/2009



Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3504-5RevC		Manufactured	No			170	Each	14.0000	2.0000			
												
Crossbolt Spacer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
36181	14	

D3505-1RevA	Manufactured	No	170	Each	0.0000	1.0000
						
Web						
D3506-3RevA	Manufactured	No	170	Each	16.0000	2.0000
						

2 2E 09/09/02

B-51708 MB 09-08-37

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	16	
50563	16	

2 BE 9/9/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			240	Each	3,628.000	38.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 3628

105855 16

108606 52

111529 1560

111779 ✓ 2000

MS20601-AD4W3

Purchased

No

240

Each

282.0000

12.0000



Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 282

107823 3

111359 279

38 MD 09/05/21

12 BE 9/9/2

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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ALS4-1032-225

Purchased

No

260

Each

8,834.000

1.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8834

107441

16

110768 ✓

8818

AN3C4A

Purchased

No

260

Each

842.0000

31.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

842

112082

40

112314

802

AN3C5A

Purchased

No

260

Each

550.0000

2.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

550

111424

8

111707 ✓

342

112314

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 08/24/2009

Required Date: 09/07/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R10		Purchased	No			260	Each	594.0000	2.0000			



Screw



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	594	
108062 ✓	135	
108167	35	
110049	424	

2 mo 09/09/24

AN960C10L

Purchased

No

260

Each

3,352.000

33.0000



washer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	3252	
112116 ✓	3252	

33 mo 09/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 08/24/2009

Required Date: 09/07/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2965-3RevB		Manufactured	No			260	Each	6.0000	1.0000			



Cap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

50560 ✓

6

6

260

Each

17.0000

1.0000

1 MD 09/09/21

D2965RevB



Cap, 105 Skidtube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP4

50609

50924

Main Warehouse

ST

43288

46800

50924 ✓

7

2

5

10

6

5

-1

1 MD 09/09/21

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3492-041RevC		Manufactured	No			260	Each	3.0000	4.0000			
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Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43816

3

3

D3492-043RevC		Manufactured	No			260	Each	0.0000	4.0000			
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Plug Assembly

D3492-047RevC		Manufactured	No			260	Each	56.0000	2.0000			
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Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

56

27776

1

28961

39

39722

16

D3508-1RevC		Manufactured	No			260	Each	0.0000	1.0000			
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Wearplate

51261

X4 MD 09/09/21

X4 MD 09/09/21

X2 MD 09/09/21

1 MD 09/09/21

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation



Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3508-3RevC		Manufactured	No			260	Each	1.0000	1.0000			
												
Wearplate												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

46881

1

D3508-5RevC

Manufactured

No

260

Each

0.0000

1.0000



Wearplate

D3508-7RevC

Manufactured

No

260

Each

3.0000

1.0000



Wearplate

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

44518

3

D3558-1RevB

Manufactured

No

260

Each

23.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

23

50925

23

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Shop Packet Print

Page 8

1 MD 09/09/21

X1 MD 09/09/21

X1 MD 09/09/21

X1 MD 09/09/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3558-3RevB		Manufactured	No			260	Each	6.0000	1.0000			



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

6

45661

6

D3558-5RevB

Manufactured

No

260

Each

14.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

14

50926

14

D3558-7RevB

Manufactured

No

260

Each

21.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

21

36388

2

43245

5

50927

14

X1 MP 09/09/24

X1 MP 09/09/24

X1 MP 09/09/24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1611-007

Purchased

No

260

Each

447.0000

1.0000

2



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

447

103697

447

NAS1611-010

Purchased

No

260

Each

345.0000

1.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

NAS1611-013

Purchased

No

260

Each

320.0000

1.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

X2

MA 09/09/21

X4

MO 09/09/21

X4

MD 09/09/21

P10 - D

W/O: 51385		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-01-21		change qty on BOM to match drawing pg. 1	JD	09/07/28		CA	

Part No: D135-751-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation


Start Date: 08/24/2009

Required Date: 09/07/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			280	Each	842.0000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	842	
112082	40	
112314	802	

112720 SP

AN960C10L



washer

Purchased

No

280

Each

3,352.000

8.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	3252	
112116	3252	

9/9/05

12

112116 SO

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51385

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 08/24/2009

Required Date: 09/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3506-1RevA		Manufactured	No			280	Each	7.0000	4.0000			



Doubler

Handwritten mark

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

3

46538

3

Main Warehouse

ST

4

50562

4

D3512-1RevC

Manufactured

No

280

Each

3.0000

2.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST500

3

51133

3

*Handwritten: * ① 51390*

Handwritten: ① 51133 9/2/25 ① 54

August 20, 2009 3:20:34 PM

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

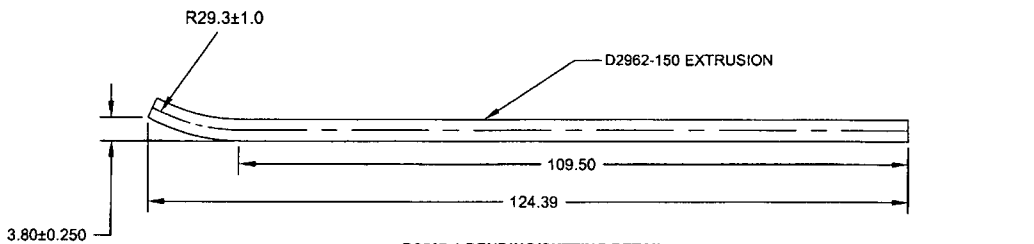
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

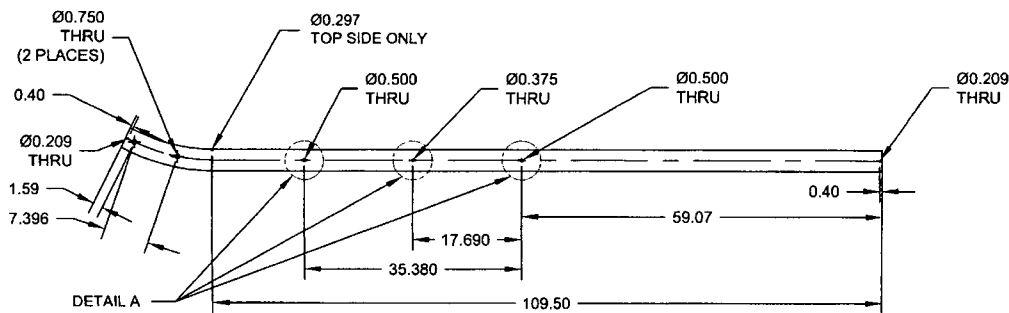
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

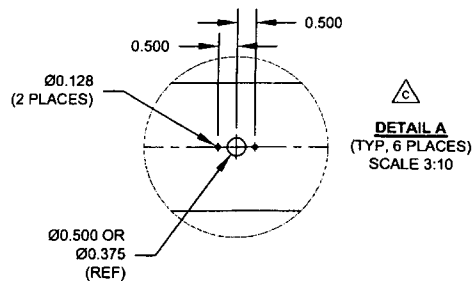
#51385
mf
09-08-20



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	RC		
CHECKED	BE		
MFG. APPR.	EP		
APPROVED	JP		
DE APPR.			
DATE	07.09.19		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3507 REV. C
SHEET 1 OF 2

TITLE EC 135 SKIDTUBE SCALE NTS

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RELEASED
07.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 204

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 505370
Part number: D135 751 011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier J. D. Dml Date of Test Coupon 09-07-16
Welder Barclay Elliott Date of Test Coupon 09/07/16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld